

Work Order ID 152376

Monday, October 24, 2016 11:17:53 AM

152376

Page 1

Item ID: D205-564-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bell Medium Bearpaws

Start Date: 10/24/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/4/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **OCT 24 2016**

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D205-564	H I 16-12-09 DAS 6 9-89	NOV 08 2016						16-11-08	
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy blue file and type labels per PPP D205-564-011 CHG009								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

DEC 08 2016

NOV 09 2016

DEC 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D205-564-011
LOCATION: FG015X2
DAS
27
9-89

DEC 08 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.03

DAS
21
9-89

DEC 09 2016

Quality Control

DAS
21
9-89

DEC 09 2016

DEC 09 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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D205-564-011

Required Date: 11/4/2016

Required Qty: 2.00

Comments: IPP F00.01.20Changed pick list, MPP 2019, CHG006EC
IPP Rev:G 06-08-28 As per Rev E JLM
IPP Rev:H 08-01-11 Added Step #2 JLM Verified BY:EC
IPP Rev:I 08-10-01 New Manufacturing Method JLM Verf By:EC IPP
REV:J 15.06.05 as per ecn15-574/chg009 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2274 *D2274* Radius Block		Manufactured	No			110	Each	201.0000	20	40			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		12							
				86855		12							
				ST006		189							
				150353		34							
				150676		155							
D2521 *D2521* Individual Bearpaw		Manufactured	No			110	Each	1.0000	2	4			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST479a		1							
				142767		1							
D2529 *D2529* Washer		Manufactured	No			110	Each	603.0000	20	40			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST008		603							
				150080		500							
				150996		103							
D3544-041 *D3544-041* Clamp		Manufactured	No			110	Each	0.0000	4	8			
									**				

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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152376

Parent Item: D205-564-011

D205-564-011

Parent Item Name: Bell Medium Bearpaws

Start Date: 10/24/2016

Required Date: 11/4/2016

Start Qty: 2.00

Required Qty: 2.00

D4060-1 Manufactured No

110 Each 11.0000 8 16

D4060-1

Ski Clamp, Top

**

6x B152452

DAS 28 26 27
9-89 9-89 9-89
NOV 09 2016

Location

Loc Qty

Loc Code

ST542

11

151770

11

D4061-1 Manufactured No

110 Each 0.0000 8 16

D4061-1

Ski Cushion

**

5x B119172
1x 151509

AN4-13A

Purchased No

110 Each 265.0000 8 16

AN4-13A

Bolt

**

DAS 28 26 27
9-89 9-89 9-89
NOV 09 2016

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

35

m134634

19

m135470

16

ST343

210

m134852

36

m135470

174

AN4-15A Purchased No

110 Each 1,033.000 20 40

AN4-15A

Bolt

**

DAS 28 26 27
9-89 9-89 9-89
NOV 09 2016

Location

Loc Qty

Loc Code

GA

26

120449

26

over003

1000

m135859

1000

ST343

7

m135774

7

40x

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Shop Packet Print

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Parent Item Name: Bell Medium Bearpaws

Start Date: 10/24/2016

Required Date: 11/4/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0463J

Purchased

No

110

Each

2,230.000

20

40

NAS1149D0463J

Washer

DAS
28
9-89

DAS
26
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

cnc	200	
M135671	200	
GA	135	
M134508	32	
M135056	103	
ST260a	1000	
M135767	1000	
ST263	895	
M135530	95	
M135671	800	

NOV 09 2016

40x

MS21042L4

Purchased

No

110

Each

2,214.000

20

40

MS21042L4

Nut

DAS
28
9-89

DAS
26
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001	34	
m133363	34	
GA	260	
m135058	260	
OVER007	1500	
m135774	500	
m135864	1000	
ST303	420	
m135704	420	

NOV 09 2016

40x

Add as per ECN 16-656
D5245-7 x 1 each kit.
Lm.

DAS
27
9-89

B 13/03

NOV 7 8 2016

DAS
28
9-89

DAS
26
9-89

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

Work Order ID 152376

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152376

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Item ID: D205-564-011**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Bell Medium Bearpaws**Start Date:** 10/24/2016 **Start Qty:** 2.00***2*****Cust Item ID:****Required Date:** 11/4/2016 **Req'd Qty:** 2.00***2*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run****Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp****Draw Nbr****Revision Nbr**

D205-564

I

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy blue file and type labels per PPP D205-564-011 CHG009

DAS
21
9-89

NOV 08 2016



110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.01

Quality Control

5.0 PARTS LISTS

Note: Additional fasteners may be included depending on the configuration being installed.

5.1 Parts List Bearpaw Installation

(For Skid tubes equipped with Standard Wearplates)

Qty -011	Qty -013	Qty -015	Part Number	Description
X			D205-564-011	BEARPAW INSTALLATION
	X		D205-564-013	BEARPAW SKI INSTALLATION
		X	D205-564-015	SKI UPGRADE KIT
20	52	36	D2274	RADIUS BLOCK
2	2		D2521	BEARPAW
20	12	12	D2529	WASHER
4			D3544-041	CLAMP
	2	2	D3795-1	SKI FWD SECTION
	2	2	D3795-3	SKI MID SECTION
	2	2	D3796-041	FWD WEARPLATE
	2	2	D3796-043	AFT WEARPLATE
8	26	18	D4060-1	CLAMP (REPLACES D2947)
8	26	18	D4061-1	CUSHION (REPLACES D2182B055)
	8	8	AN4-12A	BOLT
20			AN4-15A	BOLT
	52	52	AN4-20A	BOLT
20	52	32	NAS1149D0463J	WASHERS (OR AN960JD416)
	8	8	AN970-4	WASHER
20	60	40	MS21042L4	NUT (OR MS21042-4)

5.2 Parts List Bearpaw Installation

(For Skid tubes equipped with Standard and Training Wearplates)

Qty -111	Part Number	Description
X	D205-564-111	BEARPAW INSTALLATION
20	D2274	RADIUS BLOCK
20	D2529	WASHER
4	D3544-041	CLAMP
6	D4060-7	CLAMP
2	D4060-9	AFT BEARPAW CLAMP
8	D4061-1	CUSHION
2	D5423-1	BEARPAW
16	AN4-20A	BOLT
20	AN4-22A	BOLT
20	NAS1149D0463J	WASHERS (OR AN960JD416)
20	MS21042L4	NUT (OR MS21042-4)